

[illegible]

Work Order ID 154206

Tuesday, December 06, 2016 2:50:36 PM

154206

Page 3

Item ID: D4436-043 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Aft Outboard Bracket Assembly
Start Date: 11/30/2016 Start Qty: 2.00 ***2*** Cust Item ID:
Required Date: 12/6/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	QC5- Inspect part completeness to step on W/O	0.00							DAS 9 9-89
150									
QC	Memo	0.01							
Quality Control									
160	Chemical Conversion Coat per QSI005 4.1	0.00							
160									
HandFinish	Memo	0.05							
Hand Finishing									
170	QC7-Inspect Chemical Conversion Coat	0.00							
170									
QC	Memo	0.00							
Quality Control									

(x2) 16-12-22 2017/01/10

2 17/01/10 DAS 36 9-89

Tuesday, December 06, 2016 2:50:36 PM

154206

Page 4

N900040100

Setup Start *NS1*

Stop *NS2*

~

Cust Item ID:

Start Date: 11/30/2016 **Start Qty:** 2.00

~

Customer:

Required Date: 12/6/2016 **Req'd Qty:** 2.00

Reference:

Run Start *NR1*

Approvals: **Process Plan:** **Date:** **Tooling:** **Date:**

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180		0.00							
180						2x			12/01/10
Small Fab	Memo	0.03							
Small Fab	Assemble as per dwg, do not install rubber seal.								
185	QC5- Inspect part completeness to step on W/O	0.00							
185						2			DAS 38 9-89
QC	Memo	0.01							
Quality Control									JAN 10 2017
190	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
190									
Powdercoat	Memo	0.02							
Powder Coating	START TIME: 8:35 OVEN TEMPERATURE: 200 FINISH TIME: 9:05					2	0	17-01-10	38 34 9-89

Work Order ID 154206

Tuesday, December 06, 2016 2:50:36 PM

154206

Page 5

Item ID: D4436-043

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Aft Outboard Bracket Assembly

Start Date: 11/30/2016 Start Qty: 2.00

2

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Required Date: 12/6/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

200

QC3- Inspect Part Finish

0.00

200

QC

Memo

0.00

Quality Control

2 FF JAN 17 2017

202

0.00

202

Small Fab

Memo

0.05

Small Fab

Install rubber seal as per dwg

3M 1300 batch: 11348712 FF JAN 17 2017

205

QC5- Inspect part completeness to step on W/O

0.00

205

QC

Memo

0.01

Quality Control

2 FF DAS
38
0-88

JAN 18 2017

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Tuesday, December 06, 2016 2:50:36 PM

154206

Page 6

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Required Date: 12/6/2016 Req'd Qty: 2.00 ***2*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
210	Identify as per dwg & Stock Location: <u>ST621</u>	0.00				2			
210									
Packaging	Memo	0.00							
Packaging									
220	QC21- Final Inspection - Work Order Release	0.00							
220									
QC	Memo	0.03							
Quality Control									

JAN 20 2017

Picklist Print

Tuesday, December 06, 2016 2:50:36 PM

Page 1

Work Order ID: 154206

154206

Parent Item: D4436-043

D4436-043

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.10.06 new issue EC verified by:DD
12.01.24 PER DWG REV.A DD VERF:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D4441-1		Manufactured	No			202	f	0.0001	1.408	2.816			
---------	--	--------------	----	--	--	-----	---	--------	-------	-------	--	--	--

D4441-1

Rubber Seal

FF

JAN 17 2017

Location

Loc Qty

Loc Code

ST422 151347
120932

0.0001
0.0001

2.816

M6061T6S.040

Purchased

No

100

sf

272.8100

1.59

3.347368

M6061T6S 040

6061-T6 .040 Sheet

**DAS
46
9-89**

16/12/12

Location

Loc Qty

Loc Code

MAT021

272.81

m135147
m135612
m135632
m135724

0.92
38.27
84.78
148.84

4

MS20426AD3-2

Purchased

No

180

Each

18,145.00

4

8

MS20426AD3-2

Rivet

**17/01/10
DAS
36
9-89**

Location

Loc Qty

Loc Code

Mezz

18145

1173
13276

8865
9280

**M135274
(8x)**

Picklist Print

Page 2

Tuesday, December 06, 2016 2:50:36 PM

Work Order ID: 154206

154206

Parent Item: D4436-043

D4436-043

Parent Item Name: Aft Outboard Bracket Assembly

Start Date: 11/30/2016

Required Date: 12/6/2016

Start Qty: 2.00

Required Qty: 2.00

MS21075L08

Purchased

No

180

Each

183.0000

2

4

MS21075L 08

ANCHOR NUT

DAS
36
9-89

12/01/10

Location

Loc Qty

Loc Code

ST298

183

M135774

108

M136182

75

M128635
4X

DQA: _____ Date: _____



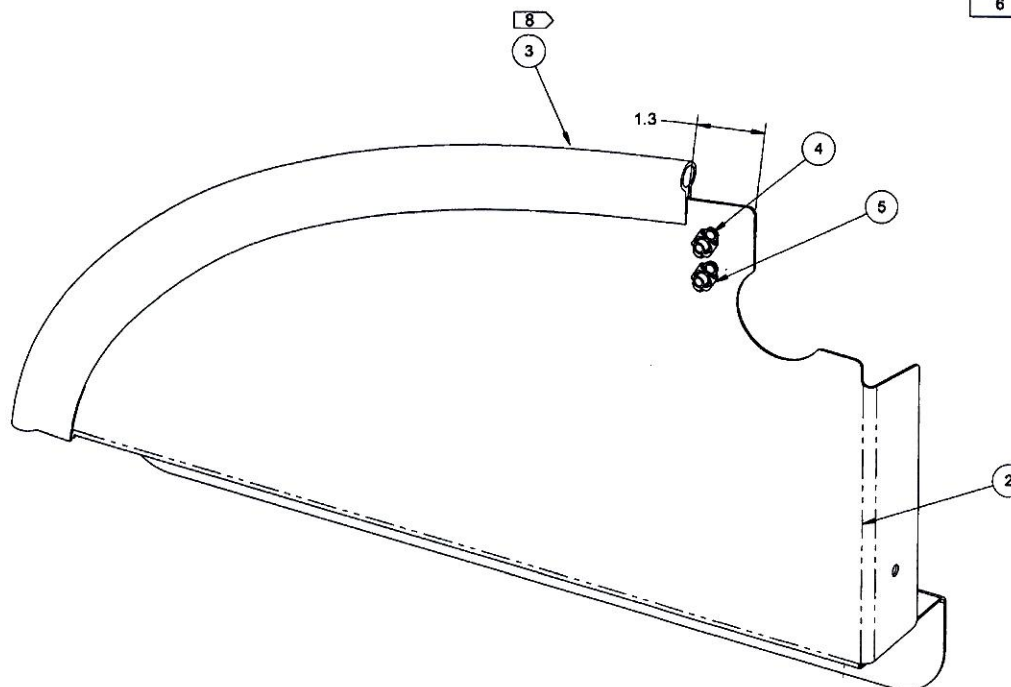
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																
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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval																																																																
Description Work Order Deviation		Disposition		Completed By																																																																
				Lead hand / Supervisor Approval Verification																																																																
				QC / QA Coordinator Approval																																																																
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OTHER :																																																																				

ITEM	QTY -043	PART NUMBER	DESCRIPTION
1	X	D4436-043	AFT OUTBOARD BRACKET ASSEMBLY
2	1	D4436-1	BRACKET
3	1	D4441-1-160	RUBBER SEAL
4	4	MS20426AD3-2	RIVET
5	2	MS21075L08	NUT PLATE
6	A/R	3M 1300/1300L	ADHESIVE



D4436-043 AFT OUTBOARD BRACKET ASSEMBLY

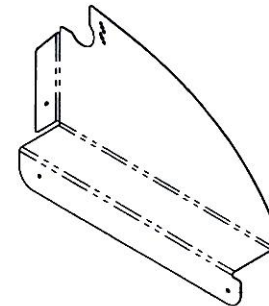
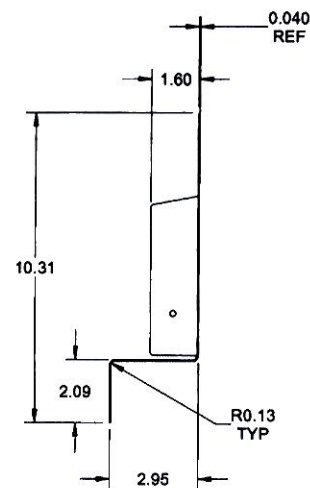
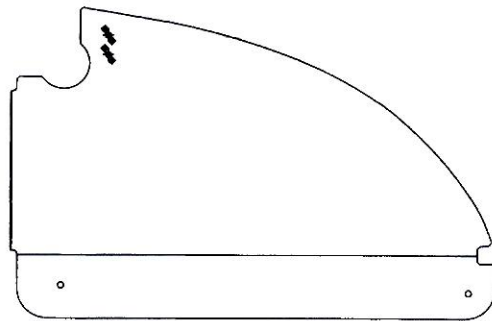
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
MASK NUT PLATE HOLES
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.78 lbs
- 8) INSTALL RUBBER SEAL TO EDGE OF PART AFTER POWDER COAT USING 3M 1300/1300L ADHESIVE
ENSURE BRACKET IS COMPLETELY INSERTED INTO GROOVE OF RUBBER SEAL.
IT IS ACCEPTABLE TO NOTCH THE SEAL AS REQUIRED TO PREVENT IT FROM BUCKLING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 154206 ML5
1612-07

2012-01-23

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO. D4436	REV. A
MFG. APPR.	RF		SHEET 2 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



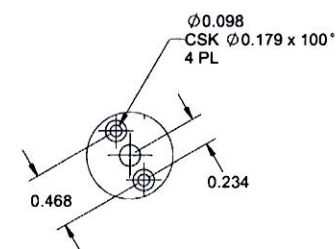
D4436-1 BRACKET

NOTES:

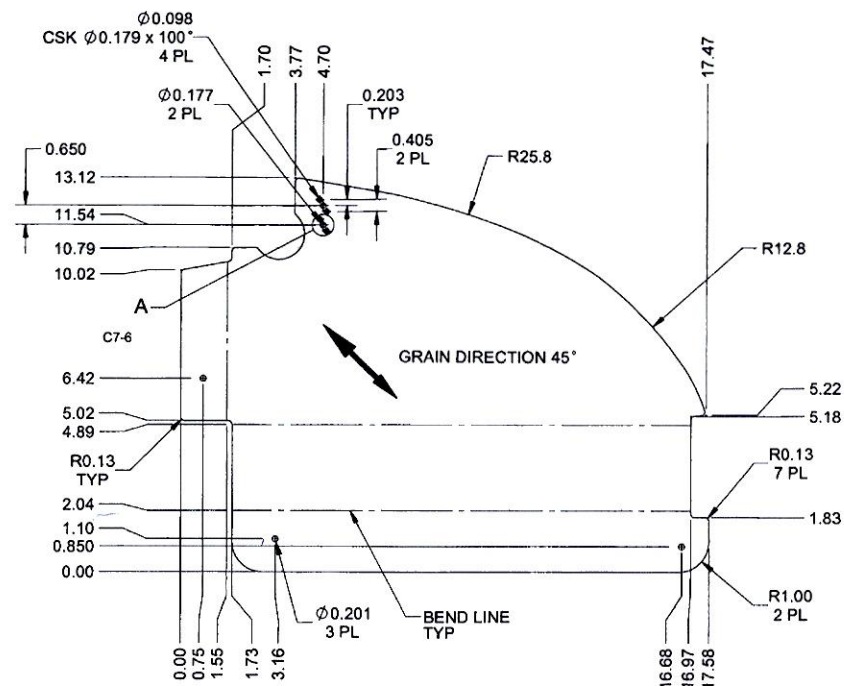
- 1) MATERIAL: MAKE FROM D4436-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4436	SHEET 4 OF 7
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	COVER ASSEMBLY	NTS
DATE	12.01.17	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

RELEASE
2012-01-23



DETAIL A C6-6
SCALE 4X, TYP



D4436-1F FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET 0.040 THICK
PER QQ-A-250/11 OR AMS-QQ-A-250/11
OR AMS 4025 OR AMS 4027
OR ASTM B209
REF DART SPEC. M6061T6S.040
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.69 lbs

RELEASED
2012-07-23

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4436	SHEET 5 OF 7
APPROVED		TITLE	SCALE
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